Page 1 March 12, 2010 12:27:41 PM D3676-1 Item ID: Accept Setup Start **Revision ID:** Stop **BUBBLE WINDOW** Item Name: **Start Date:** 12/03/2010 **Start Qty: Cust Item ID: Required Date: 26/03/2010** Reg'd Qty 3/00 **Customer:** Reference: Start Run Date: 0-3-/2 Tooling: **Process Plan:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Reject Accept Reject Insp. **Work Center ID** Description Qty **Run Hours** Number Rev. Qty Number Code Stamp Draw Nbr **Revision Nbr** D3676 Rev B 100 0.00 HAND FINISHING THERMOFORMING Thermoform 0.00 Memo Thermoforming Machine Set up Machine as per folio FTA 018 and D3676 program 110 0.00 HAND FINISHING THERMOFORMING Thermoform 0.00 Memo Thermoforming Machine Cut Blanks to 33.5" by 50" 120 0.00 THERMOFORMING MACHINE

Thermoform

Memo

Thermoform as per Dwg. D3676 and Folio FTA 018 □ Dwg. Rev. Thermoforming Machine

□Folio Rev.

0.00

Dart Aerospace Ltd	Dar	tΑ	ero	spa	ace	Ltd
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W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	PROCEDURE CHANGE			Ву	Date 0	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cat	egory:	NCF	l: Yes	No DQA: _		Date:		
		solution:									
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DATE STEP		Description of NC			ction B		Verificati	on	Approval	Approval	
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Work Order ID 56899

March 12, 2010 12:27:41 PM

Required Date: 26/03/2010



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Item ID:

D3676-1

Accept



Setup Start



Revision ID:

Item Name: **Start Date:**

BUBBLE WINDOW

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



12/03/2010

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

130

Quality Control

Operation Description

Start Qty: 3.00

Req'd Oty: 3.00

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours**

Draw Number

Draw Plan Rev. Code

Accept **Qty**

Reject Reject Oty

Insp.

Number Stamp

Memo

0.00

0.00

1) Check Surface finish for undesired marks, voids, dimples etc. 2) Check

depth of bubble to ensure conformity to drawing tolerances.

140

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

150

Thermoform

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Thermoforming Machine

1) Trim off excess flange material (2) Buff out any light scratches or

blemishes (3) Etch part number and batch number

	•												
W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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		Section A	Chief Eng	Action Description Chief Eng	Dat		ion C	Chief Eng	QC Inspector				
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Work Order ID 56899

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Item ID:

D3676-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

BUBBLE WINDOW

Start Date:

12/03/2010

Start Qty: 3.00

Required Date: 26/03/2010

Req'd Qty: 3.00



Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Start Run



QC:

__ Date:____

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**

160

Quality Control

Operation **Description**

QC2- Inspect parts off machine FAI/FAIB

Memo

Memo

Memo

Set Up/ **Run Hours** 0.00

Number Rev.

Draw Plan Code

Accept Oty

Reject Reject Qty

Insp. Number Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

1) VIsually inspect for clarity, and proper formation.

180

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

Packaging

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	Res	olution:						Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)		-	
DATE STEP		Description of NC			ion B	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng			on C	Chief Eng	QC Inspector
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Work Order ID 56899	Work	Or	der l	D	56899
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March 12, 2010 12:27:41 PM

Required Date: 26/03/2010



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Item ID:

D3676-1

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

BUBBLE WINDOW

12/03/2010

Start Qty: 3.00

Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals:

Date: _____

Tooling:

Date:

Run

Start



Process Plan:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Operation Work Center ID

Description QC21- Final Inspection - Work Order Release Set Up/ **Run Hours** Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

190

Memo

0.00

0.00

Quality Control

									
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STED	STEP Description of NC Section A			ion B	Verifi	ication	Approval	Approval
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Picklist Print

March 12, 2010 12:27:45 PM

Work Order ID: 56899

Parent Item:

Comments:

D3676-1

Parent Item Name:

BUBBLE WINDOW

IPP Rev A New Product

01/24/2008 DL Verified:JLM IPP Rev B Change Mat. to .236"" 08/29/2008 DL

Start Date: 12/03/2010

Required Date: 26/03/2010

Start Qty: 3.00

Required Qty: 3.00

Date

Issued

Component Item ID/ Item Name

MACRLICS.236

Replacement Mfg/ Item ID Purch Purchased

Bin Primary Item Location No

Last Location Route Seq ID Unit of Measure Hand

Remaining Qty on Qty To Pick 240.0000 39.0195

Qty Issued

Status

Page 1

Plexiglass G .236"

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	240		
110577	99		
113571	141		

sf

W/O:			WO	RK ORDER CHANGE	ES								
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No):	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _					
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DATE STEP		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval				
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DART AEROSPA	ACE LTD			Wo	rk Order:	:56899,
Description:	4/12 Dussiz 6	J12000		Pa	rt Number:	1) 3676-1
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Inspection Dwg:	عاره Rev:	<u>5</u>				Page 1 of 1
	FIRST AI	RTICLE INSF	PECTION	CHECK	LIST	
	X	First Article		Prototyp	e	
	TH	HERMOFORM	IING SE	CTION		
Description			Accept	Reject	Method of Inspection	Comments
Inside Radii less tha	an"		~_			
Shape Definition						
Texture Retention Material imperfectio	ns such as humns	cracks voids	-			
scratching						-
Measured by:	22		l	L	Date:	13/03/17
measured by.	.02		J		Date.	1 10/02/17
		TRIMMING	SECTIO	ON .		<u> </u>
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
46		46.626				
29.1		29,875				
.050	Mis	,073				
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GP0.	H:2	, 107				
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Audited b	py: M]		Date:	10/03/17
Prototype Approv	al:]		Date:	

Revised by KJ/DL Approved

Change New Issue

Rev

Α

Date

D3676-1 412 BUBBLE WINDOW

SHOP COMY RETURNIO ENGINEERING UNCONTROLLED CET Y SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 56 29 NO. 3-12

NOTES:
1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
OR POLYCAST I! CLEAR ACRYLIC SHEET PER MIL-P-5425,
0.236 THICK (STOCK REF. DART SPEC. M-ACRYLIC-S.236)

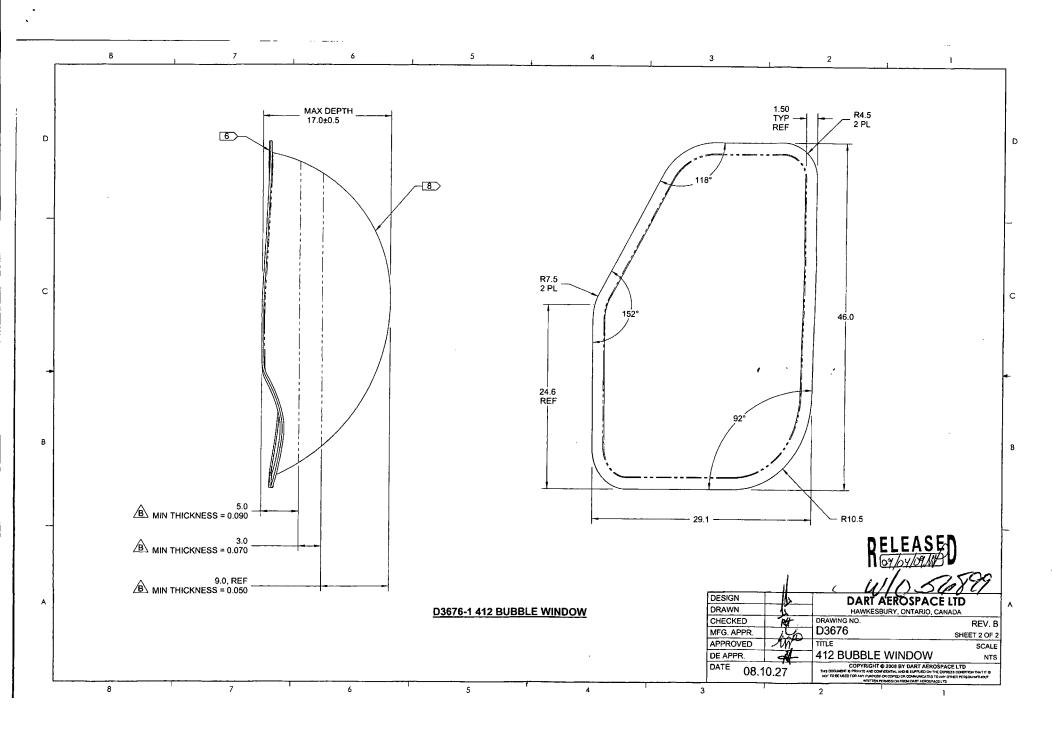
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: ENGRAVE P/N "D3676-1" & B/N "BXXXXX" ON FLANGE WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"

7) WEIGHT: 11.0 lbs 8) VACUUM FORM PER FOLIO FTA018 USING DT8992 MOLD AND DART QSI 022

REVISED TOLERANCE ON MINIMUM THICKNESSES (ZN A8/B8-2). REASON: PRODUCTION FACILITY. 08.10.27 Α MB 08.02.29 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3676 MFG. APPR SHEET 1 OF 2 APPROVED TITLE SCALE 412 BUBBLE WINDOW DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD
THE DOCUMENT IS PRIVATE AND CONFOCUTUL AND IS EMPILED ON THE EXPRESS COME
NOT TO BE USED FOR MAY PURPOSE OR COYED OR COMMUNICATED TO ANY OTHER PIZE. DATE 08.10.27

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